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D5661-046
Job Sheet 202509

Part No: D5661-046

Job Qty: 4 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5661 Rev A / DSK182 Rev A IPP Rev. A 19.09.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	4 pcs		11/29/19	0.17	1.00	Waterjet - Flow		JRB 12/7/19
120	QC 2	4 pcs		11/29/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S238063

Part: D5661 - 046

Job No: 202509

Serial No/Batch: S238063

Revision: A/A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/07/19

130 QC 8	4 pcs	11/29/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	12/7/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	DAS
				QC 8 - 68	DEC 09 2019 68
				QC 8 - 67	9-89
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Small Fab - Brake NC - B4B	4 pcs	11/29/19	0.25 0.67	Small Fab - Brake - 1 - B4B	DAS 30 9-89
				Small Fab - Brake - 2 - B4B	DEC 13 2019
				Small Fab - Brake - 3 - B4B	
150 QC 5	4 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
155 Automated Welding - B4B	4 pcs	11/29/19	0.25 0.67	Automated Welding - 1 - B4B	
160 Large Fab - Welded Assy-2-	4	11/29/19	0.00 2.00	Large Fab - 1 - B4B	

B4B	pcs			Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
170 QC 9	4 pcs	11/29/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	DAS
				QC 9 - 24	24
				QC 9 - 43	9-89
				QC 9 - 50	
				QC 9 - 9	
180 QC 5	4 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	DAS
				QC 5 - 24	24
				QC 5 - 3	9-89
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	DAS
190 Spray Paint - 2 - B4B	4 pcs	11/29/19	0.00 0.33	Spray Paint - 1 - B4B	41 DEC 14 2019
				Spray Paint - 2 - B4B	8-89
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
200 QC 5	4 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	

DAS
31
-89

210 Packaging 3-1 - Stock - B4B	4 pcs	11/29/19	0.00 0.00	QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PK WR001
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	4 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	8-89

Part Op 110 - 1-Cut DSK182-5F as per DWG. DWG. Rev: A PROG. Rev: A 2-Deburr if necessary

Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - FORM D5661-5F WEARPLATE AS PER DWG

150 - (QC5- Inspect part completeness to step on W/O)

155 - ***USE DT10493*** APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) BATCH: M139005

160 - ***MINIMUM 7 WELDS DISTRIBUTED ACROSS SHIM AND MINIMUM 1 WELD PER INDICATED COLUMN*** 1- WELD SHIMS AS PER DWG A/R Hardcoat S.S. Batch: M176585 2- TRANSFER DRILL 00.188 DRAIN HOLE FROM WEARPLATE THRU SHIM

170 - (QC9- Inspect visual per QSI004- Fusion Welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - 1- COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9 BATCH: 5235921 2- OPEN UP DRAIN HOLE IF NECESSARY TO 0.188 AFTER APPLYING TEXTURED COATING AS PER DWG 3- INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER AFTER FINISH

200 - (QC5- Inspect part completeness to step on W/O)

210 - (Identify as per dwg & Stock Location: _____)

220 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	8.6400 sf (2.16 ea)	110-Waterjet - Flow - 1	5232322
D4682-13	Saddle Shim	4 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	5229876
D4682-9	Wearplate Shim	4 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	5230680
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S18GA	9	162	0
160-Large Fab - Welded Assy-2- B4B	D4682-13	4	72	0
	D4682-9	4	64	0
Part Specifications				
Specifications could not be found.				

Plex 10/30/19 7:23 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	202509
Description: <i>Wearplate Assembly</i>		Part Number:	DS661-046
Inspection Dwg: <i>DSK182</i>	Rev: <i>A</i>	<i>DSK182-6</i> Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<i>Ø 0.188</i>	<i>H0.005 -/0.001</i>	<i>0.190</i>	<i> </i>		<i>JRB-01V</i>	
<i>0.500</i>	<i>+/- 0.010</i>	<i>0.497</i>			<i>JRB-02V</i>	
<i>0.775</i>	<i>+/- 0.010</i>	<i>0.773</i>			<i>Tape</i>	
<i>0.650</i>	<i>+/- 0.010</i>	<i>0.646</i>				
<i>5.275</i>	<i>+/- 0.010</i>	<i>5.277</i>				
<i>2.638</i>	<i>+/- 0.010</i>	<i>2.638</i>				
<i>0.90</i>	<i>+/- 0.030</i>	<i>0.90</i>				
<i>1.80</i>	<i>+/- 0.030</i>	<i>1.82</i>				
<i>35.77</i>	<i>+/- 0.030</i>	<i>35.77</i>				
<i>40.00</i>	<i>+/- 0.030</i>	<i>40.00</i>				
<i>3.88</i>	<i>+/- 0.030</i>	<i>3.89</i>				
<i>2.775</i>	<i>+/- 0.010</i>	<i>2.776</i>				
<i>20.47</i>	<i>+/- 0.030</i>	<i>20.48</i>				
<i>8.41</i>	<i>+/- 0.030</i>	<i>8.45</i>				
<i>1.65</i>	<i>+/- 0.030</i>	<i>1.65</i>				
<i>3.88</i>	<i>+/- 0.030</i>	<i>3.88</i>				
<i>7.75</i>	<i>+/- 0.030</i>	<i>7.75</i>				
<i>2.50</i>	<i>+/- 0.030</i>	<i>2.51</i>				
<i>1.250</i>	<i>+/- 0.010</i>	<i>1.252</i>				
<i>5.6</i>	<i>+/- 0.030</i>	<i>5.6</i>				
<i>12.1</i>	<i>+/- 0.030</i>	<i>12.1</i>				
<i>18.6</i>	<i>+/- 0.030</i>	<i>18.6</i>				
<i>24.5</i>	<i>+/- 0.030</i>	<i>24.7</i>				

Measured by: <i>JRB</i>	Checked by:	QC Inspector:
Date: <i>12/7/19</i>	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

NCR No.

Job: _____
Part No. _____

Date : _____

Sequence #:

QTY Affected :

MRB (QS1042)

DISPOSITION

DEPARTMENT/PROCESS

Skid-tube
Machining
Large Fab

Cross tube
Small Fab
Finishing

Eng. (Non-AW)
Prod. Eng. Coord.
Rec/Store/Packaging

Engineering
Water Jet
Supplier
Quality

Description Work Order Deviation

Disposition

Root Cause

FAULT CATEGORY

Operator
Manufacturing Process
Equip/Tooling
Handling/Preservation
Material
Product Improvement
Process Improvement
Human Factors

Pressure/Forced
Bending
Crushing
Cracks
Crimp/Kink/Ripple/Wave/Twist
Marks/Chatter
Mislabeled
Other/Details:

Contamination
Misaligned/off center
BOM/Route
Broken/Damage/Defect
Incomplete/Unclear Instructions
Drill Holes
Fit/Function

Power Loss/Surge
Folio/Program
Grain Direction
Weld
Wrong Stock Pulled
Out of Sequence
Off-set/Set-up

Positioned Wrong
Outside Tolerance
Drawing
Finish
Part Lost/Missing
Misread